Thursday, 6/15/2006 1:41:51 PM

User:

Kim Johnston

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 27562

**Estimate Number** 

: 10336

AIL:

P.O. Number This Issue

: 6/15/2006

: NA

: 27151

: NC

**Part Number** 

: D2807

**Drawing Number** 

**Drawing Name** 

: D2807 REV C

: GAS SPRING

**Project Number** 

: N/A

**Drawing Revision** 

Material Due Date : 7/15/2006

50 Um: Qty:

Each

**Previous Run** Written By

Prsht Rev.

First Issue

Checked & Approved By

Comment

: Est: D 05-96.21

Type

Removed painting; Changed supplier

: PURCHASED PARTS

KJ/JLM

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

**Description:** 

PG 1.0



PURCHASING



Comment: PURCHASING

1515 Issue P/O:



L'accordination



Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

2.0

SXF6S6050080S6L115N

GAS SPRING



Comment: Qty.:

1.0000 Each(s)/Unit

Total:

50.0000 Each(s)

SUPPORT PROP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached





4.0

QC6



Comment: DIMENSIONAL CHECK

5.0

D28073

Lug



Comment: Qty.:

2.0000 Each(s)/Unit

Total: 100.0000 Each(s)

Pick:

Page 1

Form: rprocess

## Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector				
						·					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification					
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector			
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Part No:	PAR #:	Fault Category: NCR	<b>R</b> : }	Yes No DQA:	Date: <u>06/08/02</u>
NOTE: Date & initial all entries	•		C	QA: N/C Closed:	Date:

Thursday, 6/15/2006 1:41:51 PM Date: ' Kim Johnston User: **Process Sheet** Drawing Name: GAS SPRING Customer: CU-DAR001 Dart Helicopters Services Part Number: D2807 Job Number: 27562 Job Number: Description: Seq. #: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 6.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Install lugs and crimp using DT8791 crimp jig: ケタの 2-Remove lettering and logo with wash and wipe. 5 AD O6:07:20 INSPECT WORK TO CURRENT STEP QC5 7.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 PACKAGING 1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock A 06/02/01 Location: DOCUMENT CONTROL 9.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion c106/08/02

## **Dart Aerospace Ltd**

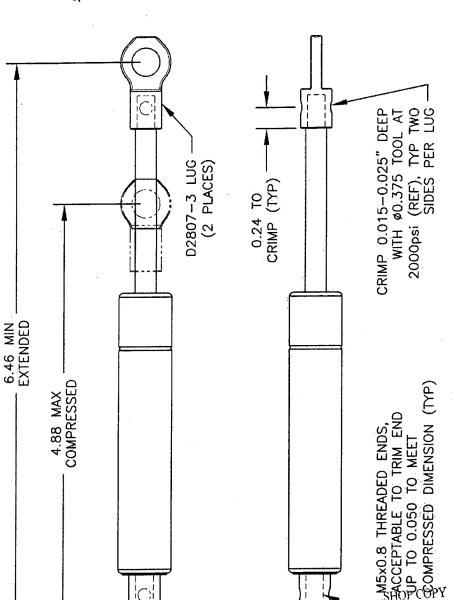
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Part No	):	PAR #:	Fault Category	:NCR:	Yes No	DQA:	Date:	
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	AH!	一脚	D2807 SHEET	1 OF 2
DATE			TITLE	SCALE
05.0	)5.25		GAS SPRING	, 1:1
Α		00.11.03	NEW ISSUE	
В		05.03.16	ADD FINISH	
С		05.05.25	CHANGE SPRING TO SS, ADD -3 L	_UG

ELEASED THOSOGIL



SS GAS SPRING.
ACCEPTABLE LOAD RANGE IS 25 Ib MIN TO 45 Ib MAX M5x0.8 THREADS

DZBOT GAS SPRING SPECIFICATION: ArvinMeritor Motion Control Systems, Leicester, UK P/N: SXF6S6050080S6L-115N

(REF: BOmm LONG CYLINDER, 50mm STROKE, 115N LOAD)

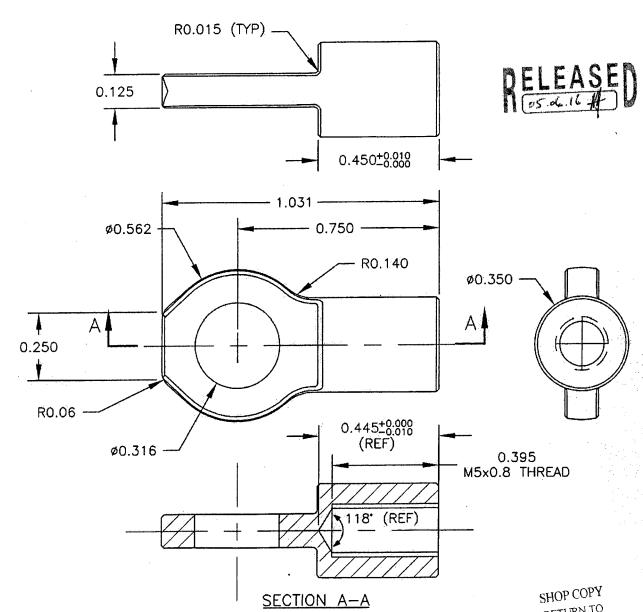
TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED 

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CHECKED	APPROVED #	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE	***************************************	TITLE	SCALE
05.05.25		GAS SPRING	3:1



## D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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YOUR ORDER WAS FACKED BY Certified that the whole of the supplies detailed hereon have been inspected and tested and unless otherwise stated conform in all respects with the

DATE 100706

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